



GENERAL INFORMATION:

8-514 HS420 Speed Clear is a polyurethane high quality clear coat with high durability for application over WaterBase 900* Series, for repairs on passenger cars. This clear coat is specially developed for body-shops with a high production or where short drying times are required.



COMPONENTS:

8-514	HS420 Speed Clear
8-550	HS420 Speed Clear Hardener
1-141	Uni Thinner Fast
1-151	Uni Thinner Medium
1-161	Uni Thinner Slow
8-539	HS420 Speed Clear Additive
47-39	2K Elastic
1-231	Fade-Out Thinner



SUBSTRATES:

WaterBase 900* Series (MM 900-999)



SURFACE PREPARATION:

Base coat should be fully dry.



MIXING RATIO:

3 : 1 + 10%	Clear Coat : Hardener + 10% Uni Thinner
3 : 1 + 10%	Clear Coat : Hardener + 10% Additive 8-539



ADDITIVES:

8-539	HS420 Speed Clear Additive
47-39	2K Elastic (information see TDS)



POTLIFE at 20°C (68°F):

	Uni Thinner	8-539
Potlife (min.)	40	20



GUN SET UP:

	Nozzle size (mm)	Spraying pressure (bar/psi)
HVLP	-	-
HE	1,2-1,4	2,0-2,5/ 29-36
Pressure pot	-	-



APPLICATION:

1,5-2 coats 40-70 µm (1.6-2.8 mil)



1,5 coats: No flash off
2 coats: 5 min. flash off between coats



FLASH OFF & DRY TIMES:

		Flash off before bake (min.)	Dry to handle (min.)	Dry to polish (min.)
Air Dry 20°C (68°F)	Uni Thinner	Not recommended for Air Dry		
	8-539	Not recommended for Air Dry		
Forced Dry 60°C (140°F)	Uni Thinner	5	20	After cooling down
	8-539	5	10	



CLEAN UP:

1-051 Gun Cleaner



PHYSICAL DATA:

EU regulations		
VOC code	2004/42/IIIB(d)(420)360	
Product sub category (according directive 2004/42/EC) and max VOC content (ISO 11890-1/2) of the ready to use product	IIB/d. Topcoat - All types. EU limit values: 420g/l. (2007). This product contains a maximum of 360 g/l VOC.	
Physical properties		
8-514	Chemical Base	Clear polyurethane finish
	Specific gravity	0,961 g/l
	Flash point closed cup	39°C
	Vol. % solids	51
Ready to spray	Viscosity	18 sec Din Cup4 20°C (68°F)
	Economy	10 m²/L/50 µm
	Gloss	High Gloss
	Colour	Clear

STORAGE /SHELF LIFE:

8-514	HS420 Speed Clear	min. 2 years
8-539	HS420 Speed Clear Additive	min. 2 years (not below 5°C)

(Under normal storage conditions and unopened tins)

8-514 (ROW/EC)

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